

## **AMENDMENTS TO THE CLAIMS:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

### **Listing of Claims**

Claims 1-8 (canceled)

9. (new) Method for producing a cam for a clutch, comprising the steps of  
forming the cam (6) in segments and providing a cylindrical outer surface (13), a cylindrical inner surface (14), two lateral conical surfaces (15) and the two end faces (16, 17), disposing a cam journal (18) on the cylindrical outer surface (13) of the cam (6), and milling the inner surface (14), the two conical surfaces (15) and/or the two end faces (16, 17) of the cam (6),  
forming the cam (6) on a first process step so that the cylindrical outer surface (13) has its nominal finished size and the cam journal (18) has an excess length,  
mechanically machining the cam in a second process step, wherein the cylindrical outer surface (13) of the cam (6) is received and clamped in a clamping device for milling the cylindrical inner surface (14), the two lateral conical surfaces (15) and the two end faces (16, 17), and  
turning off the excess length of the cam journal (18") in a lathe.

10. (new) Method according to claim 9,  
wherein forming the cam (6) comprises prototyping or reshaping performed by a cold or warm process.

11. (new) Method according to claim 10, further comprising a step of  
soft-annealing the cam (6) after forming, and phosphatizing and calibrating the cylindrical outer surface (13) of the cam (6).

12. (new) Method according to claim 9,  
wherein a threaded bore (20) is formed in the excess length region of the cam journal (18'), and

that the threaded bore (20) is used for clamping the cam (6').

13. (new) Device for milling the contour surfaces of a cam, comprising

a clamping vise (21) which clamps the cam (6') without covering the contour surfaces to be milled,

wherein the clamping vise (21) is configured for clamping a cam tensioning bar (22) and the cam tensioning bar (22) has at least one receiving V-block (23) for the cylindrical outer surface (13) of the cam (6') and a clamping device for the cam (6'), wherein the clamping direction of the clamping device for the cam (6) is oriented radially with respect to the clamping direction of the clamping vise (21) and against the receiving V-blocks (23) of the cam tensioning bar (22).

14. (new) Device according to claim 13,

wherein the clamping device for the cam (6') comprises a through bore (24) in the cam tensioning bar (22) disposed in a region of the receiving V-block (23), and a tensioning screw (25) for the threaded bore (20) of the cam (6').

15. (new) Device for shortening of the cam journal,

wherein the device comprises a sleeve-like clamping element (26) with at least one radial opening (28) and a clamping sleeve (29) with a clamping mandrel (30), wherein the outside diameter and the inside diameter of the cylindrical clamping element (26) correspond to the outside diameter and the inside diameter of the outer swivel element (1) of the clutch, the radial opening (28) is designed for receiving the cam journal (18"), and the clamping mandrel (30) and the clamping sleeve (29) match the cylindrical inner surface (14) of the cam (6').

16. (new) Device according to claim 15,

wherein the sleeve-like clamping element (26) comprises a stepped through bore (27) with a radial shoulder, and the shoulder of the through bore (27) is configured as an axial limit stop for the cam (6').